

Work Order ID 126644

March-17-15 11:08:24 AM

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Page 1

Item ID: D5108-1 **Accept** ***N900040100*** **Setup** **Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Relay Bracket
Start Date: 11/19/14 **Start Qty:** 5.00 ***5*** **Cust Item ID:**
Required Date: 11/19/14 **Req'd Qty:** 5.00 ***5*** **Customer:**
Reference:

Approvals: **Process Plan:** W **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5108	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	***CHECK GRAIN DIRECTION***								
	1-Cut as per Dwg								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

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02/15/03/17

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02/15/03/17

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Item ID: D5108-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Relay Bracket

Stop *NS2*

Start Date: 11/19/14 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 11/19/14 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

130	Bend as per dwg	0.00	
130	NC BRAKE		
Brake NC	Memo	0.00	DAS 6 15/03/22
Brake NC			30
			9-89

140	QC5- Inspect part completeness to step on W/O	0.00			
140					
QC	Memo	0.00			
Quality Control					

6

DAS

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00				6	15-3-23		
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.00				6			DAS 41 9-89 15-3-26
Quality Control									
170		0.00							
170									
SprayPaint	Memo	0.00				6			DAS 41 9-89 15-3-26
Spray Painting	1- PRIME TEMPO GRAY AS PER DWG AND QSI PRIMER BATCH: <u>130573</u>								

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC14- Inspect Spray Paint	0.00							DAS 38 9-89
180									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location <u>8148</u>	0.00							DAS 26 9-89
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

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MS-3.31

Picklist Print

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Parent Item: D5108-1

D5108-1

Parent Item Name: Relay Bracket

Start Date: 11/19/14

Required Date: 11/19/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 14.04.23 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.050

Purchased

No

sf

196.3777

1

M6061T6S 050

6061-T6 .050 Sheet

02/15/03/17

Location

Loc Qty

Loc Code

MAT021

196.3777

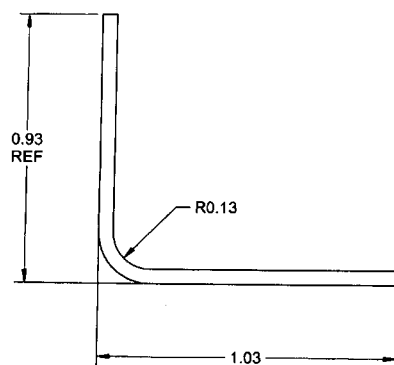
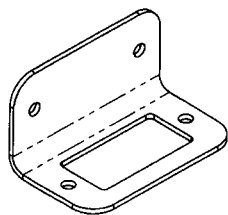
125636

12.3777

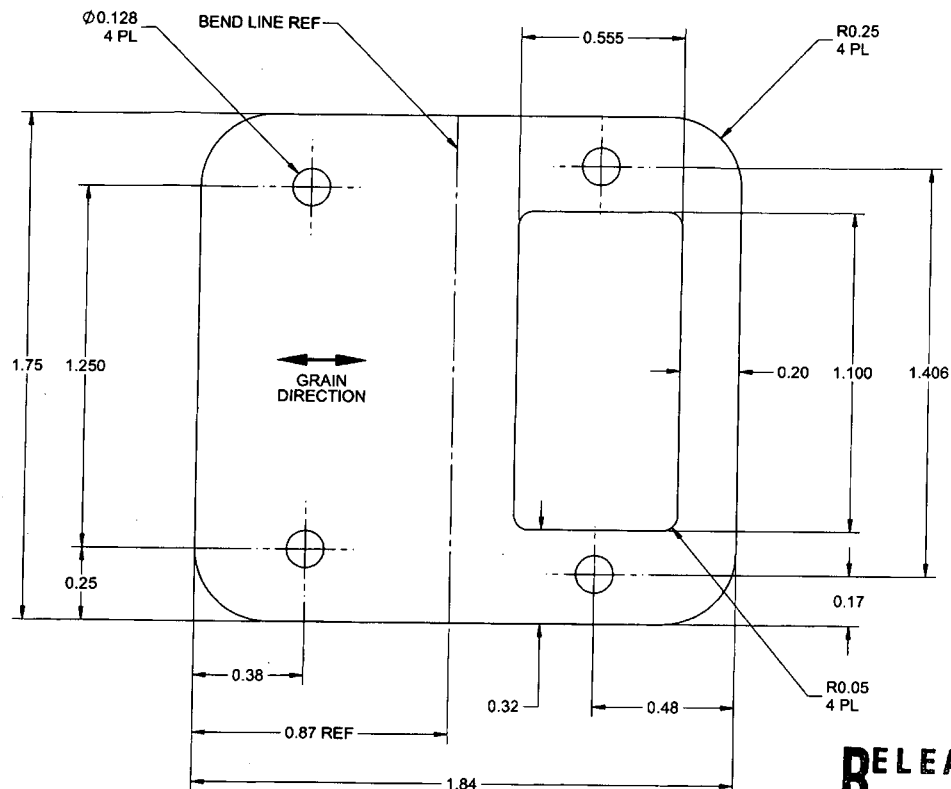
m131352

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D5108-1 RELAY BRACKET



D5108-1F RELAY BRACKET
(FLAT PATTERN)

RELEASED
2014-05-12

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.50 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.7
- 7) WEIGHT: 0.01 lbs

A		NEW ISSUE		ML	14.04.23
REV.	DESCRIPTION			BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	ML			SHEET 1 OF 1	
CHECKED	AP	DRAWING NO.		SCALE	
MFG. APPR.	DD	D5108		NTS	
APPROVED	MP	TITLE		SCALE	
DE APPR.	DS	RELAY BRACKET		NTS	
DATE		14.04.23		COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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